

Work Order ID 71371 - 2

Thursday, June 30, 2011 8:20:13 AM



Page 1

Item ID: D2965

Revision ID:

Item Name: Cap. 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00

Required Date: 7/15/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan:

QC:

Date: 11/06/30 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2965

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14401 Cast per Dwg D2965 Material Release Note Required

CY 11/06/30 50

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

11/14/11 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Subsistor

100000

(450)

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Item ID: D2965

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap. 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 50.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Drill as per Dwg D2965 with DT8538 Deburr and Tumble

SP 11/08/09 (2)

140



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/10/09

(+2)

150



Powdercoat

Powder Coating

Powdercoat

1115125

0.00

Memo

0.00

Mask as per Dwg D2965 Powder To match Skidtube(Ref: 4.3.5.x) as per QSI 005 4.3 START TIME: *1:00pm* OVEN TEMPERATURE:

1:30pm FINISH TIME:

3209

- Black sandtex.

x2 of 11/10/09

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Item ID: D2965

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap, 105 Skidtube

Start Date: 6/30/2011 Start Qty: 50.00

Required Date: 7/15/2011 Req'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2x Ø m-11/08/04

170



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

Install Inserts as per Dwg D2965

2x Ø m-11/08/04

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sublog

Ⓢ

Work Order ID 71371

Thursday, June 30, 2011 8:20:13 AM



Page 4

Item ID: D2965

Revision ID:

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Start Date: 6/30/2011 Start Qty: 50.00

Required Date: 7/15/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

Memo

Set Up/
Run Hours

0.00

0.00

200



QC

Quality Control

QC21 - Final Inspection - Work Order Release

Memo

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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m-1/0 m-1/11/08/09

OK 11/08/09

11-08-9
(2)

Picklist Print

Thursday, June 30, 2011 8:20:10 AM

Page 1

Work Order ID: 71371



Parent Item: D2965

Parent Item Name: Cap, 105 Skidtube

Start Date: 6/30/2011

Required Date: 7/15/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: A 00.05.31 New Issue EC
IPP Rev: Added Turning as per Rev B 06-12-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-225

Purchased

No

170

Each

700.0000

2

100



INSERT

m-k 11/08/11

Location

Loc Qty

Loc Code

ST282

700

100896

100

111529 ✓

300

111581

300

4X

D2965P

Purchased

No

170

Each

0.0000

1

50



Cap

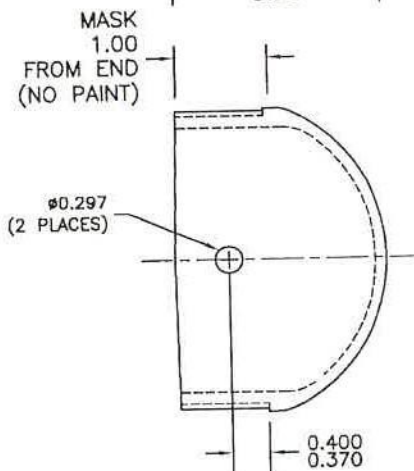
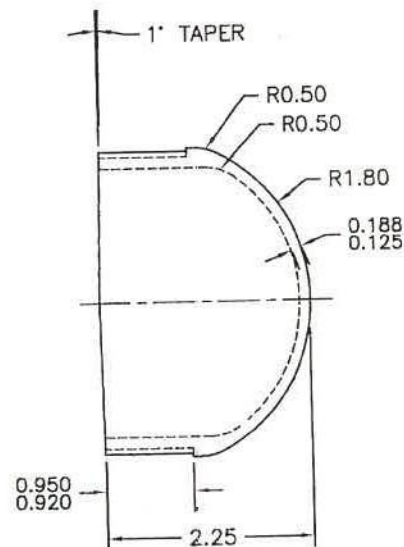
11/11/11 (S.G.)

DART

RELEASED

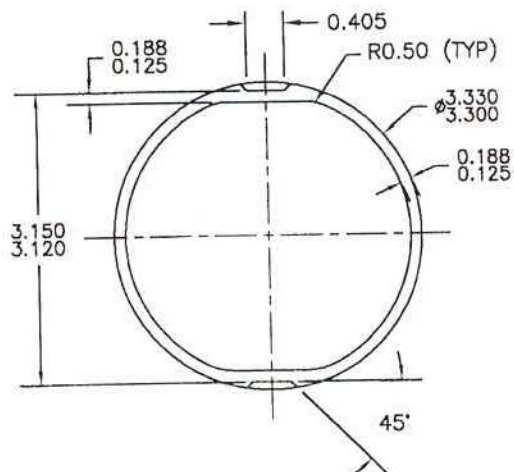
06.12.12

DESIGN	814	DRAWN BY	814	DART AEROSPACE USA, INC.	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	06.11.01	DRAWING NO.	D2965	SHEET 1 OF 2	
		TITLE	CAP	SCALE	1:2
A	00.02.24	NEW ISSUE			
B	06.11.01	ADD -3 CAP			

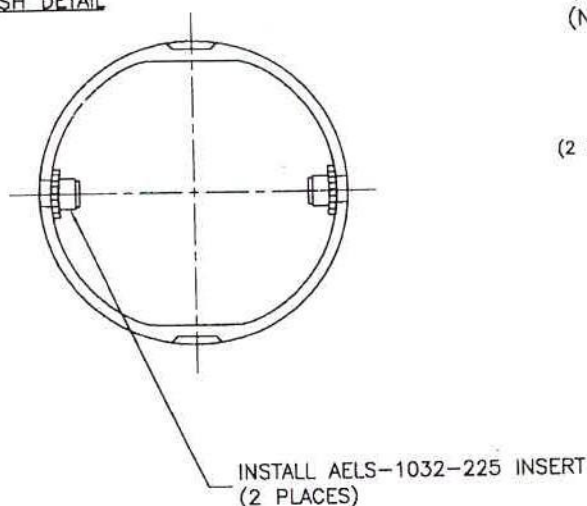


061106130
010: 71371

D2965 CASTING DETAIL



D2965 FINISH DETAIL



D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

DART

RELEASED

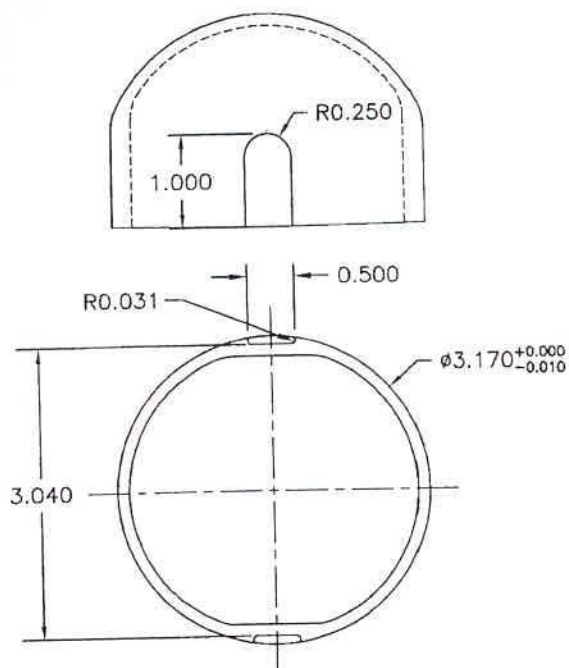
06.12.12

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.11.01	TITLE	D2965	REV. B
			CAP	SHEET 2 OF 2
				SCALE 1:2

MASK
1.00
FROM END
(NO PAINT)

Ø0.297
INSTALL AELS-1032-130
AFTER FINISH
(2 PLACES)

D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14401

Purchase Order Date 6/30/2011

PO Print Date 6/30/2011

Page Number 1 of 1

Order From : VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 683 9777	Requisition Nbr	
Vendor Fax	514 683 0375	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

REVISED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 1/10/130

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D2965P	Cap	7/18/2011 Yes	50.00 Each	FedEx PI collect	\$20.3500	\$1,017.50

Special Inst: CAST AS PER DWG D2965 REV. B
B71371

MATERIAL: CAST ALUMINUM
ALLOY A356.2 (F)

PO Total: \$1,017.50

MATERIAL CERTIFICATION
REQD UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 2

Change Date: 6/30/2011

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, Québec H9P 1K3
Tel: (514) 683-9777
Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.:

33764

Shipped Date:

03 08 2011

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 14401	
Shipped By:	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z200080	Each	D2965 CAP	50
Received by:			
Date:			
Comment:			

7 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD2225 CHEMIN ST. FRANCOIS, DORVAL, QC H9P-1K3
TEL : (514) 683-9777 FAX: (514) 683-0375Attn. Chantal
Corrected
addressExpédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Date: 03/08/2011

Packing

Slip No. 33764

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 14401

Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
50	D 2965 CAP Sublot	Z200080	A356.2	ingot#855862 B# 1120401

Analyse
Analysis (as in ingot)

(Si)	7.1%	(Al)	balance
(Fe)	0.09%		
(Cu)	0.03%		
(Mn)	0.00%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield :Résistance à la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :

Par/Per :

Coc-100

70 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: 03/08/2011 Slip No. 33764

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 14401

Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

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Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
50	D 2965 CAP	ZZ00080	A356.2	ingot#855862 B# 1120401

Analyse
Analysis (as in Ingot)

(Si)	7.1%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.03%		
(Mn)	0.00%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield:Résistance à la tension :
Tensile Strength:Allongement par pouce carré :
P.S.I. Elongation:

%

Pour et au nom de
For and on behalf of:FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100